

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005457**Date Inspected:** 10-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai ,China**CWI Name:** Luan Zhao Gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Segment Repair Yard (North of the paint shop)

Segment 3AE

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) in the 2G position of the lifting lug vertical side plates at panel point 22. The welder is identified as #058551. The weld designation is SSD18-PP22-241. ZPMC QC is identified as Mr. Luan Zhao Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-TC-U4b-F.

Flux Cored Arc Welding (FCAW) in the 2G position of the lifting lug vertical side plates at panel point 20. The welder is identified as #200114. The weld designation is SSD16-PP20-257. ZPMC QC is identified as Mr. Luan Zhao Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-TC-U4b-F.

Segment 3BE

This QA Inspector observed that there was no work being done on this segment at the time of inspection.

Segment 4AE

This QA Inspector observed that there was no work being done on this segment at the time of inspection.

Segment Repair Yard (South of the paint shop)

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

### Segment 4AW

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the TL2-2 Floor beam sub assemblies at panel point 24. The Weld Designations are as follows: FB003-004-020 and FB003-004-008.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the FL-1 Floor beam sub assemblies at panel point 24 and 25. The Weld Designations are as follows: FB015-03-026 and FB.

### Segment 5CE

This QA Inspector observed that there was no work being done on this segment at the time of inspection.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Patterson,Rodney	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

---